

# Work Order ID 50607

July 17, 2009 6:51:46 AM



Page 1

Item ID: D3826-041  
Revision ID: B  
Item Name: Rib / Gusset Assembly

Accept



Setup Start



Stop



Start Date: 07/20/2009 Start Qty: 6.00



Required Date: 07/23/2009 Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-07-17 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3826	Rev B
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100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- use DT9434 to assemble D2325 support gusset together 2- locate D2325 on rib and weld as per dwg D3826 A/R ER316 S.S. Rod  
Batch: m109313

09.07.21

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

DD 09.07.22

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 8 or 12/22

46

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D3826-041  
Revision ID: B  
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Accept



Setup Start



Stop



Start Date: 07/20/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 07/23/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: Basket

0.00



Packaging

Memo

0.00

Packaging

PD 09-07-22 (6)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/24 JF

MF 09-07-23

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 50607

Parent Item: D3826-041RevB

Parent Item Name: Rib / Gusset Assembly



Comments:

Start Date: 07/20/2009

Required Date: 07/23/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2235-1RevB1		Manufactured	No				Each	17.0000	6.0000			
												
Basket Rib												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST	9	
48665	2	
50029	7	

3 Cpl 09.07.21

Main Warehouse

WA	8	
48665	-2	
50565	10	

3 Cpl 09.07.21

D3929-041RevA

Manufactured

No



Gusset Assembly

Each 4.0000 6.0000



Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST	4	
47273	1	
48663	3	

Cpl 09.07.21

~~B50563~~

~~3x Cpl 09.07.21~~

B50566

3x Cpl 09.07.21

~~B50563~~

B50566 x3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 50607

Parent Item: D3826-041RevB

Parent Item Name: Rib / Gusset Assembly

Comments:

Start Date: 07/20/2009

Required Date: 07/23/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3929-042RevA		Manufactured	No				Each	5.0000	6.0000			



Gusset Assembly

~~B 50062 x 3~~

B 50567 x 3

Warehouse                      Loc Qty                      Loc Code

Location

Main Warehouse

ST    5

47959    2

486620    3

~~B 50062~~ →

B 50567 →

6/20/09.07.21  
~~3 6/20/09.07.21~~  
 3 6/20/09.07.21

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

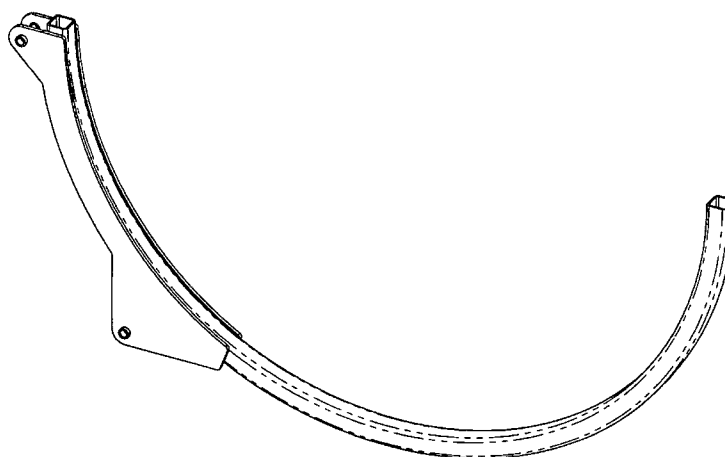
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ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSY
11	1	D2235-1	RIB
12	1	D3929-041	GUSSET ASSEMBLY
13	1	D3929-042	GUSSET ASSEMBLY

△B



**D3826-041 RIB/GUSSET ASSY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 50607  
MF 09-07-17

**RELEASED**  
8/10/12

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 3.32 lbs

△B

B	D3929-041/-042 WERE D2325 (ZN D3-1 & ZN D6-2); UPDATED WEIGHT (ZN A8-1). REASON: SEE NCR#09-042.	MB	09.04.16
A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.04.16		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3826** REV. B  
TITLE **RIB/GUSSET ASSY** SCALE NTS  
SHEET 1 OF 2

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△ B D3929-042  
GUSSET ASSEMBLY

△ B D3929-041  
GUSSET ASSEMBLY

TYP

0.250

D2235-1  
RIB

D3826-041 RIB/GUSSET ASSY

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RETURN TO  
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WORK ORDER

NO. 50607

MF 09-07-17

**RELEASED**  
9/04/16

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3826	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		RIB/GUSSET ASSY	NTS
DATE	09.04.16	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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